

# Work Order ID 65701

January 24, 2011 8:32:40 AM

Page 1

Item ID: D3404-1

Accept

Revision ID:

Item Name: GHW Lug

Start Date: 1/24/11 Start Qty: 30.00

Required Date: 2/11/11 Req'd Qty: 30.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3404	Rev C

100

0.00



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank: 2.750" long

0.00

*mk 11/02/02*

30

*Ø*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 Dwg Rev: *C* Folio Rev:

*AA* 12-Deburr

0.00

*mk 11/02/24*

30

*Ø*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

*mk 11/02/24*

30

*Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65701

January 24, 2011 8:32:40 AM

Page 2

Item ID: D3404-1

Accept

Setup Start

Revision ID:

Stop

Item Name: GHW Lug

Start Date: 1/24/11 Start Qty: 30.00

Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 30.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

SL 11/02/08

30

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location

0.00

WA  
EL

Packaging

Memo

0.00

Packaging

11/02/08 30

150

QC21- Final Inspection - Work Order Release

0.00

11/03/01

QC

Memo

0.00

Quality Control

C2 11/03/01

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

# Picklist Print

January 24, 2011 8:32:39 AM

Page 1

Work Order ID: 65701



Parent Item: D3404-1



Parent Item Name: GHW Lug

Start Date: 1/24/11

Required Date: 2/11/11

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev: A 105.09.01 New issue I KJ/JLM  
IPP rev B 09.01.28 new geometry rev.C EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	10.0700	0.2291	7.234737			
304 BAR .750 X 2.50													



SL 11/02/02

## Location

## Loc Qty

## Loc Code

MAT

10.07

115869

10.07

116765

7.24

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 65701
Description: GHW Lug		Part Number: D3404-1
Inspection Dwg: D3404	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	Ø.514	—		Ultrasonic ML-7	
R0.65	+/-0.030	R.650	—		"	
0.125	+/-0.010	.128	—		"	
0.500	+/-0.010	.500	—		"	
2.14	+/-0.030	2.144	—		"	
1.30	+/-0.030	1.302	—		"	
R2.30	+/-0.030	R.2.30	—		"	
1.14	+/-0.030	1.143	—		"	
2.58	+/-0.030	2.580	—		"	

Measured by: <i>SM</i>	Audited by: <i>SL</i>	Prototype Approval:	N/A
Date: 11/02/24	Date: 11/02/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.12	New Issue	KJ/JLM	
B	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD	

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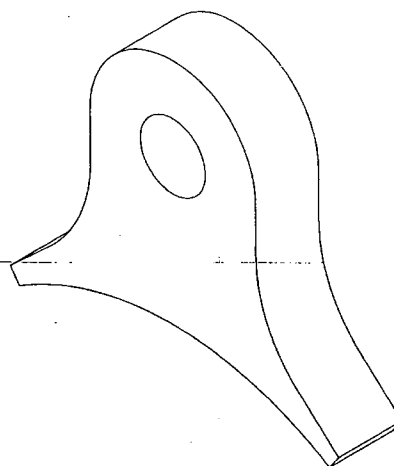
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**D3404-1 GHW LUG**

*W/B 65701*

**RELEASED**  
06/12/18 NW

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX.
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

REV.	DESCRIPTION	BY	DATE
C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13, C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3404</b> TITLE <b>GHW LUG</b> DATE <b>08.12.02</b>	REV. C
DRAWN	AJS		SHEET 1 OF 2
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		

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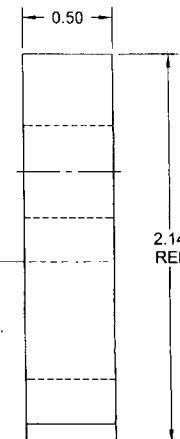
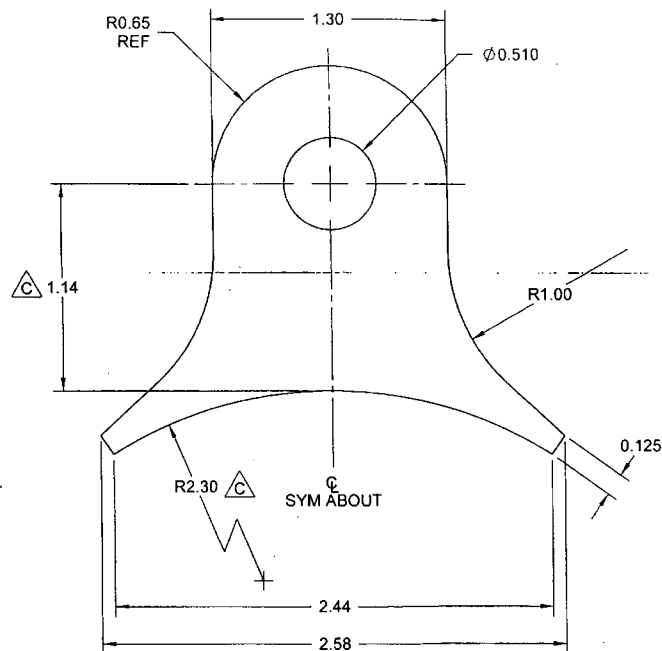
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**NOTE:** Date & initial all entries



105701

RELEASED  
08/12/02

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3404	REV. C
MFG. APPR.		TITLE GHW LUG	SHEET 2 OF 2
APPROVED		SCALE	NTG
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD	
DATE	08.12.02	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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